

Date: Wednesday, 8/15/2007 2:02:59 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ELECTRIC STEP BUSHING KIT
Job Number	: 33928		
Estimate Number	: 12987		
P.O. Number	:	Part Number	: DSI 9374011
This Issue	: 8/15/2007 S.O. No. :	Drawing Number	: DSI 9374 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	: <u>Jul 07 08 15</u>	Due Date	: 8/22/2007 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-08-10 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPDSI 9374-011 CHG 001

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D36201	BUSHING
-----	--------	---------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

BUSHING

Batch: 633873 -

4.0	AN653	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: 11105289 -

5.0	AN3106	Castellated Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Castellated Nut

Batch: 11105279 -

7/18/15

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	AN960JD616	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M104374

7.0	MS24665300	Cotter Pin
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cotter Pin

Batch: M105279

8.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP DSI9374-011 CHG 001

Location: _____

PPP Rev: _____

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C20 7/08/15

07.08.15

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D412-673 REV. A

REF. CANADIAN STC: SH96-88

REF. FAA STC: SR00563NY

26

DSI-9374-011 Electric Step Bushing Kit was created to prevent possible wear of the D205-634-011 Skidtube Kit and/or loosening of the ALS7 inserts (provided in the D412-673-011 Electric Step Kit) during normal operation of the BHT 212-706-105-003 Electric Step. The DSI kit replaces the existing ALS7 inserts and hardware with qty(4) D3620-1 Bushings and associated hardware.

- 1) Disconnect the BHT 212-075-418-001 and/or BHT 212-075-418-003 Actuators from the Dart D205-634-011 Skidtube Kit per the Aircraft Maintenance Manual. Remove and discard the qty(4) BHT 212-030-119-001 bolts that fasten then BHT 212-030-309-001 and BHT 212-030-310-001 Arms to the skidtube as shown in **Figure 1** and temporarily move the electric step away from the skidtube.
- 2) Drill out the qty(4) ALS7-428-165 inserts installed in the skidtube at the two locations shown in **Figure 1**. Drill a $\varnothing 0.406$ " pilot hole through the insert holes and the web in the centre of the skidtube. Enlarge the holes to $\varnothing 0.438^{+0.006}_{-0.000}$ ". Deburr and touch up the holes per ICA-D205-634.
- 3) Install the D3620-1 Bushings into each hole (4 places) with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant as shown in **Section A-A**.
- 4) Re-install the electric step by connecting the BHT 212-030-309-001 and BHT 212-030-310-001 Arms as shown in **Section A-A**. Ensure all nuts are installed on the inboard side of the skidtube. Re-attach the BHT 212-075-418-001 and/or BHT 212-075-418-003 Actuators to the skidtube per the Aircraft Maintenance Manual.

Parts List:

Qty -011	Part Number	Description
X	DSI-9374-011	Electric Step Bushing Kit
4	D3620-1	BUSHING
2	AN6-53*	BOLT (OR AN6C53*)
2	AN310-6	CASTELLATED NUT (OR AN310C6)
4	AN960JD616	WASHER (OR AN960C616)
2	MS24665-300	COTTER PIN (OR AN380C3-3)

* It is acceptable to replace the AN6 bolts with longer or shorter AN6 bolts as required and/or install extra AN960JD616 washers under the nut to ensure proper installation of the cotter pin.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 07.07.19
CERT. NO.: SH96-88
ISSUE NO.: 3

A	NEW ISSUE	CB	07.07.19
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9374	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ELECTRIC STEP BUSHING KIT	NTS
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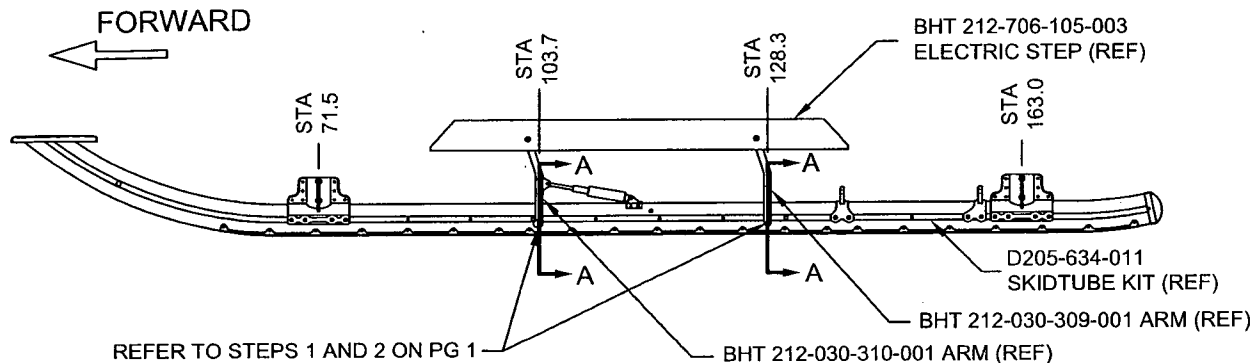
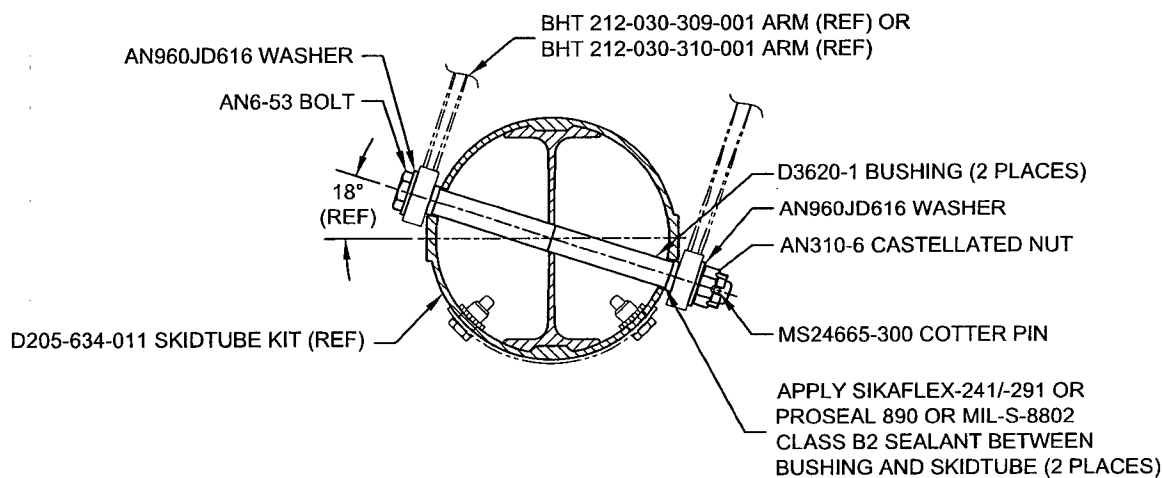


FIGURE 1 - TYPICAL BHT ELECTRIC STEP INSTALLATION
(REFER TO STEPS 1 AND 2 ON PG 1)





SECTION A-A
(REFER TO STEPS 3 AND 4 ON PG 1)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

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MFG. APPR.	N/A	DSI 9374	SHEET 2 OF 2
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